



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

647.4410

Job Sheet 214677



Part No: 647.4410

Job Qty: 6 pcs

Part Name: Rail



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/29/20

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 11/13/20

Type: SOLD

Description:

Note: DWG REV n/c SHEETS 1,2 IPP REV A RQ VERIFIED BY DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier Lead Time	
110	HAAS 4 Axis	6 pcs	11/6/20	0.09	3.22	HAAS - 1		D.L. 20-11-05
						HAAS - 2		
						HAAS - 3		
						HAAS - 4		
120	QC 2	6 pcs	11/6/20	0.00	0.00	QC 2 - 1		D.L. 20-11-05
						QC 2 - 12		
						QC 2 - 14		
						QC 2 - 17		
						QC 2 - 19		
						QC 2 - 2		
						QC 2 - 20		
						QC 2 - 22		
						QC 2 - 23		
						QC 2 - 25		
						QC 2 - 32		
						QC 2 - 33		
						QC 2 - 35		
						QC 2 - 39		
						QC 2 - 4		
						QC 2 - 40		
						QC 2 - 44		
						QC 2 - 45		
						QC 2 - 48		
						QC 2 - 49		
						QC 2 - 50		
						QC 2 - 51		
						QC 2 - 52		
						QC 2 - 57		
						QC 2 - 62		
						QC 2 - 63		
						QC 2 - 8		



Container No: S311256



Part: 647.4410
Job No: 214677
Serial No/Batch: S311256
Revision:
Inspector:
Exp Date:
Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.ca
www.dartaerospace.com



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Instructions: Various STC's

130 QC 8	6 pcs	11/6/20	0.00 0.00	QC 2 - 66	
				QC 2 - 64	
				QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 2 - 76	
				QC 2 - 86	
				QC 2 - 83	
				QC 8 - 12	
				QC 8 - 14	7/20/11/07
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
140 Outsource - 4 - Anodize	6 pcs	11/13/20	0.00 0.00	QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
				QC 8 - 66	
				QC 8 - 73	
				QC 8 - 82	
150 Packaging 2-1 - Receive - B4B	6 pcs	11/13/20	0.00 0.00	ATG001-VC	5
				Packaging 2 - 1 - B4B	
				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	

				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
				Packaging 2 - 37 - B4B	
155 QC 6	6 pcs	11/13/20	0.00 0.00	QC 6 - 9	
				QC 6 - 68	
				QC 6 - 61	
				QC 6 - 40	NOV 19 2020 DAS 40
				QC 6 - 81	9-89
				QC 6 - 82	
180 Packaging 3-1 - Stock - B4B	6 pcs <i>8 pcs ✓</i>	11/13/20	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B ✓	NOV 20 2020 DAS 80
				Packaging 3 - 4 - B4B	9-89
				Packaging 3 - 5 - B4B	<i>cek.081</i>
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	

190 QC 21 - SA	6 pcs	11/13/20	0.00 0.00	Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
				QC 21 - SA - 21	DAS
				QC 21 - SA - 70	21 NOV 20 2020
				QC 21 - SA - 9	9-89
				QC 21 - SA - 77	
				QC 21 - SA - 28	

Part Op 110 - HAAS1-1 (HAAS CNC Vertical Machine) Cut Blank at 15.00" 1-Machine per folio FB282 DWG REV: N/C
 Descriptions: FOLIO REV: AA 2- deburr and break all sharp edges
 120 - QC2 Machining-1 (QC2- Inspect parts off machine FAI/FAIB)
 130 - QC8 Machining-1 (QC8- Inspect parts - second check)
 140 - Outsource4 (Outsource process-Anodize per QSI017 4.1.10.1 Issue P/O to ATG : _____ 1- Black Anodize as per Dwg 647.4400 2- PRIME AS PER DWG, SEE NOTE #2 Certification of Conformity is required)
 150 - Packaging2 (Receive & Inspect for Damage & Mat'l Certs)
 155 - QC6 (QC6- All purchased or subcontracted products)
 180 - Packaging3-1 (Identify as per dwg & Stock Location: _____) ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***
 190 - QC21 (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
647.4400E	Rail	7.5000 ft (1.25 ea)	110-HAAS 4 Axis	92576 (10 ft)

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-HAAS 4 Axis	647.4400E	810	32	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Rail	2.000inches ± 0.010	2.010 1.990	2.000	
2	Rail	1.250inches ± 0.005	1.255 1.245	1.250	
3	Rail	0.375inches ± 0.005	0.380 0.370	0.375	
4	Rail	1.000inches ± 0.005	1.005 0.995	1.0015	
5	Rail	2.000inches ± 0.005	2.005 1.995	2.001	
6	Rail	6.996inches ± 0.005	7.001 6.991	6.996	
7	Rail	12.996inches ± 0.005	13.001 12.991	12.996	
8	Rail	14.846inches ± 0.005	14.851 14.841	14.847	
9	Rail	0.438inches ± 0.005	0.443 0.433	0.438	Radius
10	Rail	0.063inches ± 0.005	0.068 0.058	0.063	Radius
11	Rail	0.050inches ± 0.005	0.055 0.045	0.0495	
12	Rail	(0.821)inches ± 0.005	(0.816) (0.826)	0.819	
13	Rail	0.830inches ± 0.005	0.835 0.825	0.833	
14	Rail	0.340inches + 0.000 - 0.005	0.340 0.335	0.335	
15	Rail	0.900inches ± 0.010	0.910 0.890	0.903	
16	Rail	0.188inches ± 0.005	0.193 0.183	0.189	

17	Rail	0.200inches $\pm$ 0.005	0.205 0.195	0.200	
18	Rail	0.063inches $\pm$ 0.005	0.068 0.058	0.063	Radius
19	Rail	0.125inches $\pm$ 0.005	0.130 0.120	0.125	Radius
20	Rail	30.000Degrees $\pm$ 0.500	30.500 29.500	30°	Angle
21	Rail	14.025inches $\pm$ 0.005	14.030 14.020	14.022	
22	Rail	12.531inches $\pm$ 0.005	12.536 12.526	12.528	
23	Rail	0.692inches $\pm$ 0.005	0.697 0.687		
24	Rail	0.626inches $\pm$ 0.005	0.631 0.621	0.6265	
25	Rail	0.313inches $\pm$ 0.005	0.318 0.308	0.313	
26	Rail	1.906inches $\pm$ 0.005	1.911 1.901	1.9045	
27	Rail	2.101inches $\pm$ 0.005	2.106 2.096	2.100	
28	Rail	4.201inches $\pm$ 0.005	4.206 4.196	4.200	
29	Rail	6.300inches $\pm$ 0.005	6.305 6.295	6.299	
30	Rail	0.201inches $\pm$ 0.005 - 0.001	0.206 0.200	0.202	Diameter
31	Rail	0.094inches $\pm$ 0.004 - 0.001	0.098 0.093	0.094	Diameter
32	Rail	1.502inches $\pm$ 0.005	1.507 1.497	1.506	
33	Rail	0.813inches $\pm$ 0.005	0.818 0.808	0.814	
34	Rail	60.000Degrees $\pm$ 0.500	60.500 59.500	60.2°	Angle
35	Rail	23.500Degrees $\pm$ 0.500	24.000 23.000	23.4°	Angle
36	Rail	41.200Degrees $\pm$ 0.500	41.700 40.700	41.2°	Angle

Plex 10/29/20 10:17 AM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER POHB047565



Supplier: ATG001-VC
A.T.G. Industries Inc
760 INDUSTRIELLE STREET
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB047565

PO Date: 11/9/20

Due Date: 11/13/20

Purchase Order

Revision:

Revision Date:

Issued By: Lussier, Patrick
Phone: 613-632-5200 Ext: 276
plussier@dartaero.com

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	214749	647.1511	647.1500 E	Lower Deflector : Various STC's (Outsource process-Anodize per QSI017 4.1.10.1) Issue P/O to ATG : _____, Hard Anodize Color Black, Prime as per Dwg 647.1500	Firmed - X10	-	11/13/20	10 pcs	0 pcs	10 pcs	\$12.62/pcs	\$126.20
2	214677	647.4410	647.4400	Rail : Various STC's Outsource4 (Outsource process-Anodize per QSI017 4.1.10.1) Issue P/O to ATG : _____ 1- Black Anodize as per Dwg 647.4400 2- PRIME AS PER DWG, SEE NOTE #2 Certification of Conformity is required	Firmed - X8	-	11/13/20	8 pcs	0 pcs	8 pcs	\$12.27/pcs	\$98.16
3	214770	D5763-15	D5763 REV A	Stop : Various STC's ISSUE P/O: ANODIZE AS PER MIL-A-8625 TYPE2, CLASS 2, COLOR BLACK AS PER DWG C OF C IS REQUIRED	Firmed - X8	-	11/13/20	8 pcs	0 pcs	8 pcs	\$9.28/pcs	\$74.24
4	215052	D5763-17	D5763 REV A	Knob : Various STC's ISSUE P/O: ANODIZE AS PER MIL-A-8625 TYPE2, CLASS 2, COLOR BLACK AS PER DWG C OF C IS REQUIRED	Firmed - X8	-	11/13/20	8 pcs	0 pcs	8 pcs	\$9.28/pcs	\$74.24

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PURCHASE ORDER

POHB047565



Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
Grand Total:												\$372.84

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Please ensure to send the related invoice to hby_ap@dartaero.com.

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A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Pack List

Number: 921097

Date: 17-Nov-20

Ship To

Patrick Lussier
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
10 ea	Part: 647.1511 Lower Deflector Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (1 - 2 mils) per drawing. Batch/Lot#: 5306022 Expiry Date: 13/8/22 Job: 28439 Line: 1 PO: POHB047565		
8 ea	Part: 647.4410 Rail Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0006-.0009" (.6 - .9 mils) per drawing. Batch/Lot#: 5306022 Expiry Date: 13/8/22 Job: 28440 Line: 2 PO: POHB047565		
8 ea	Part: D5763-15 Stop Black Anodize per MIL-A-8625, Type 2, Class 2 Job: 28441 Line: 3 PO: POHB047565		
8 ea	Part: D5763-17 Knob Black Anodize per MIL-A-8625, Type 2, Class 2		

DAS
40
9-89

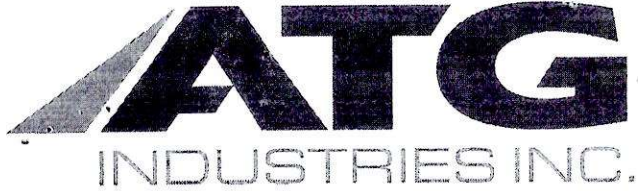
RECEIVED
NOV 17 2020
DART AEROSPACE LTD.

Made in Canada.

DAS
40
9-89

RECEIVED
NOV 17 2020
DART AEROSPACE LTD.

Made in Canada.



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 921097

Date: 17-Nov-20

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Patrick Lussier
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Job: 28442 PO: POHB047565	Line: 4	
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>NOV 17 2020</u> Certified Signature: _____ Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt. Made in Canada.			